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D3537-1
Job Sheet 202788



Part No: D3537-1

Job Qty: 60 pcs

DAS
21
9-08

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/19

Job Tracking No:

Due Date: 11/29/19

Created By: Automated MRP Engine

Type: Stock

Description:

Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD
verf:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs		
105	Waterjet - Flow - 1	60 pcs	11/29/19	11/29/19	0.17	2.58	Waterjet - Flow	JRB 12/9/19
110	QC 2	60 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

DART
AEROSPACE

Container No: S238215

Part: D3537 -- 1

Lot No: 202788

Serial No/ Batch: S238215

Inspector: F

Date:

Instructions: Various STC's

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Container No: S238215

Part: D3537-1

Job No: 202788

Serial No/Batch: S238215

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/09/19

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	SRB 12/9/19
125 QC 8	60 pcs	11/29/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	DEC 09 2019 DAS 68
				QC 8 - 67	9-89
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	60 pcs	11/29/19	0.25 0.78	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	DEC 11 2019
150 QC 5	60 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DEC 11 2019 DAS 40
				QC 5 - 61	9-89
				QC 5 - 81	
160 Automated Welding - B4B	60 pcs	11/29/19	0.00 4.45	Automated Welding - 1 - B4B	MB
170 QC 10	60	11/29/19	0.00 0.00	QC 10 - 10	

	pcs			QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
180 QC 5	60 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Packaging 3-1 - Stock - B4B	60 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-001 W 19-12-16
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
	</				

220 QC 21 - SA	60 pcs	11/29/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	2-20
				QC 21 - SA - 53	
				Broussard	

Part Op 105 - 1-Cut D3537-1 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Deburr if necessary DEC 1 6 2019

Descriptions: 125 - (QC8- Inspect parts - second check)
140 - (Form as per dwg)
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: N136075
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location:)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	6.3600 sf (.106 ea)	105-Waterjet - Flow - 1	S207058

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M304S16GA	6	277	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches ± 0.010	4.260 4.240	4.256	
2	Wearpad	3.500inches ± 0.010	3.510 3.490	3.502	
3	Wearpad	1.970inches ± 0.030	2.000 1.940	1.976	
4	Wearpad	3.630inches ± 0.030	3.660 3.600	3.619	
5	Wearpad	2.420inches ± 0.010	2.430 2.410	2.421	
6	Wearpad	0.220inches ± 0.010	0.230 0.210	0.221	
7	Wearpad	0.375inches ± 0.010	0.385 0.365	0.378	
8	Wearpad	0.063inches ± 0.010	0.073 0.053	0.063	

DAS
DEC 09 2019
9-89

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